

Work Order ID 129154

January-29-15 2:46:00 PM

129154

~~PRELIMINARY ISSUE~~

Page 1

RELEASED @ REV. C
A.R. 15.02.03

Item ID: D3152-4

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Seal

Stop

NS2

Start Date: 1/29/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/06/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3152

per Rev. C

A.R. 15.02.26

110

0.00

DAS

07

9-89

110

Thermoform

Memo

0.00

Thermoforming Machine

1- FABRICATE AS PER DWG USING TOOL DT10106 BY INJECTING
SILICONE CASTING RESIN M-SILCC-65A (MCMaster CARR
P/N:8595K77) BATCH: M131112
INSERT MOLD IN PRESSURE POT.

X1

15/02/25

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

X1

DAS 9 9-89

DAS

07

9-89

15/02/25

Work Order ID 129154

129154

Page 2

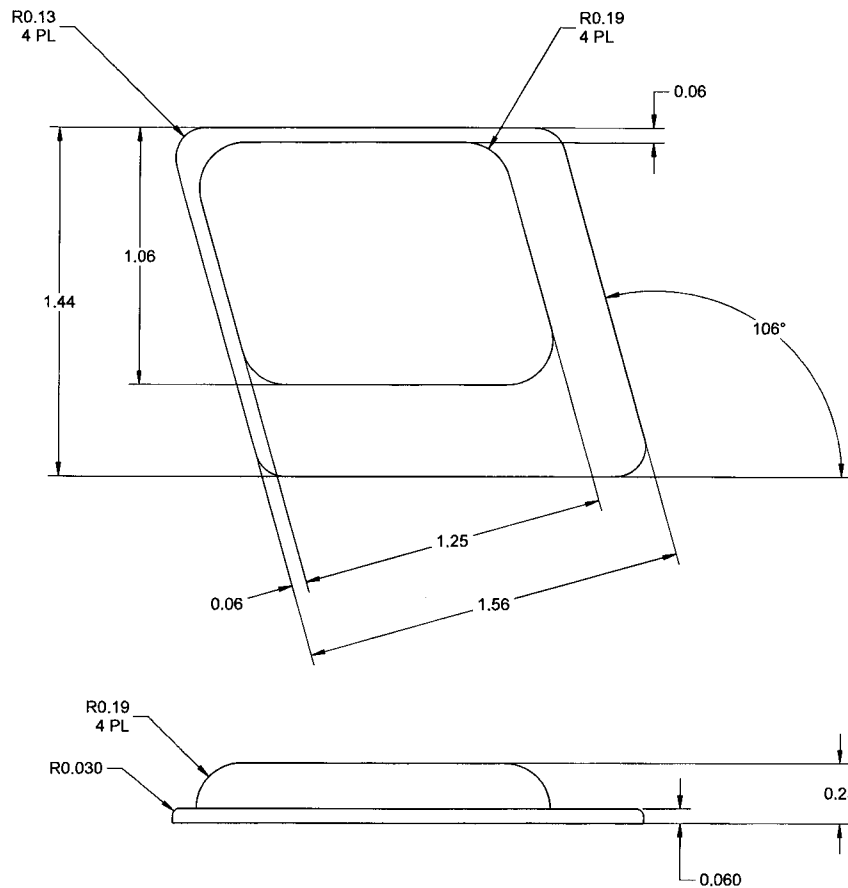
Item ID: D3152-4 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seal
 Start Date: 1/29/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							<u>B15/02/25</u>
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>CADOL</u> Memo	0.00 0.00							<u>15 -02-26</u>
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>15/3/3</u>

HB-2-26

POSITIVE RECALL
 EFFECTIVE 5.11.14 AUTH U
 RELEASED R.P. DATE 15.02.26



D3152-4 SPACEDOOR SEAL
(REPLACES PREMIER P/N B30-23000-244)

NOTES:

- 1) MATERIAL: M-SILCC-65A (2 PART SILICONE CASTING RESIN, SHORE 65A)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.02 lbs
- 8) MAKE PARTS USING TOOL # DT10106

WORK IN PROGRESS

PRELIMINARY ISSUE

DB 14.10.28

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. PC1
MFG. APPR.		D3152	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	14.10.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

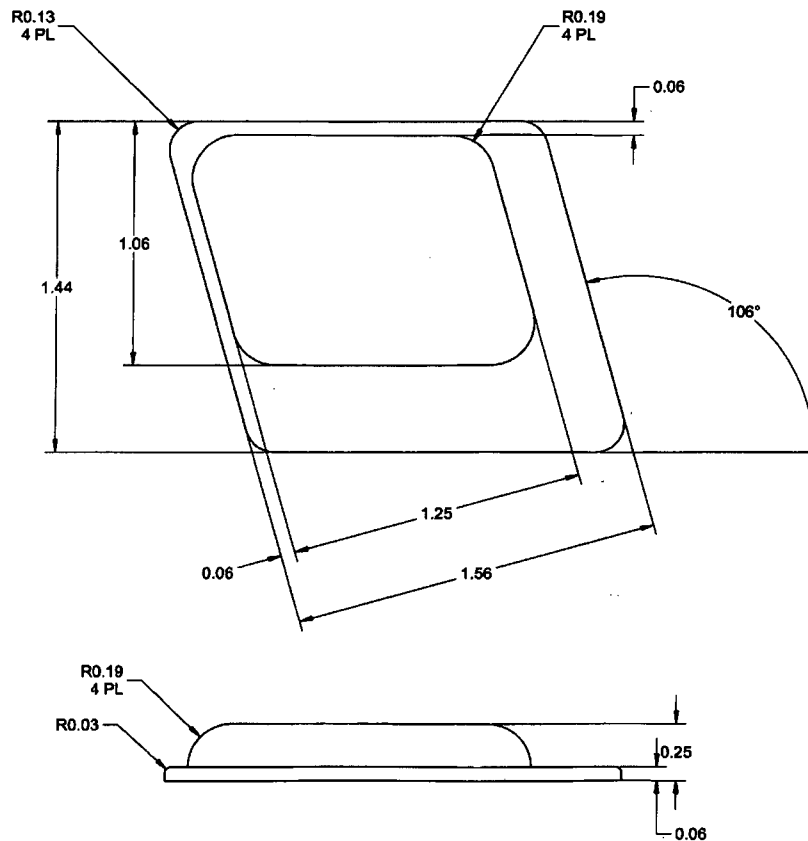
DART AEROSPACE LTD		Work Order: <u>D31512915-1</u>
Description: <u>Sec1</u>		Part Number: <u>D3152-4</u>
Inspection Dwg: <u>Pet</u>	Rev: <u>Rev C PD 15-02-26</u>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.44	± .030	1.43	✓		vern	
1.06	↓	1.05	✓		↓	
.06		.06	✓			
1.25		1.23	✓			
1.56		1.55	✓			
106°	1/2°	106°	✓		protractor	
.250	± .030	.25	✓		↓	
.060	± .010	.063	✓			

Measured by: <u>DAS 9-89</u>	Audited by: <u>38 9-89</u>	Preliminary Approval:
Date: <u>15-02-26</u>	Date: <u>FEB 26 2015</u>	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



D3152-4 SEAL
(REPLACES PREMIER P/N B30-23000-244)

RELEASED

2015 FEB 13 *sp*

NOTES:

- 1) MATERIAL: M-SILCC-65A (2 PART SILICONE CASTING RESIN, SHORE 65A)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.02 lbs
- 8) MAKE PARTS USING TOOL # DT10108 AND QSI 006 SECTION 4.18

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
DATE	14.10.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	